

Work Order ID 72592

Wednesday, August 03, 2011 8:08:23 AM

Page 1

Item ID: D407-667-105TRN

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Turning Detail

Start Date: 8/3/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D407-667-145

Rev C U/R

100

0.00



Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio FA249

2-Turn first side as per Folio FA249

3-Blend transition lines only, **do not sand whole tube**

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

1 Ø
M.M.L, 11/08/22
1 Ø
M.M.L 11/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72592

Wednesday, August 03, 2011 8:08:23 AM



Page 2

Item ID: D407-667-105TRN

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Setup Start



Revision ID:

Item Name: Crosstube Turning Detail

Stop



Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00							
	Mori Seiki								
Mori Seiki CNC Lathe Large	Memo	0.00							
	1-Turn second side as per Folio FA249								
	2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.								
	3-Remove sand and plugs								
	4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145 inside of Cuff(Do not engrave on outside of tube)								
130	QC1- Inspect dimensions to dimension sheet	0.00							
	QC								
Quality Control	Memo	0.00							

t Ø
mm.l 11/08/22

l Ø
mm.l 11/08/22

W/O:		WORK ORDER CHANGES					
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Wednesday, August 03, 2011 8:08:23 AM



Page 3

Item ID: D407-667-105TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning Detail

Stop



Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DP/DP

11-8-23

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

TW

11-08-25

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-8-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Turning Detail

Start Date: 8/3/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and stock in Kanban rack Location: 46

11-8-26

180

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

CL11108124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, August 03, 2011 8:08:31 AM

Page 1

Work Order ID: 72592

Parent Item: D407-667-105TRN

Parent Item Name: Crosstube Turning Detail


Start Date: 8/3/2011

Required Date: 8/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:a 08.02.28 new issue EC
IPP Rev B 08.04.02 Removed polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6010-115  Crosstube Material		Manufactured	No			110	Each	29.0000	1	1			

Location

LG

38343

Loc Qty

29

29

Loc Code

1 08/08/22

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 72592
Description: Crosstube Assembly	Part Number: D407-667-145
Inspection Dwg: D407-667-145 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	✓		vern	CNC-08
	1.865	+0.005/-0.000	1.870	✓		"	
	1.878	+0.005/-0.000	1.883	✓		"	
	1.970	+0.005/-0.000	1.975	✓		"	
	2.030	+0.005/-0.000	2.034	✓		"	
	2.165	+0.005/-0.000	2.170	✓		"	
	0.125	+/-0.010	.125	✓		vern	CNC-08
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	R0.063	+/-0.010	.063	✓		"	
	4.438	+/-0.030	4.418	✓		vern	CNC-06
SIDE B	2.240	+0.005/-0.000	2.242	✓		vern	CNC-08
	1.865	+0.005/-0.000	1.869	✓		"	
	1.878	+0.005/-0.000	1.881	✓		"	
	1.970	+0.005/-0.000	1.975	✓		"	
	2.030	+0.005/-0.000	2.034	✓		"	
	2.165	+0.005/-0.000	2.170	✓		"	
	0.125	+/-0.010	.125	✓		vern	CNC-08
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	R0.063	+/-0.010	.063	✓		"	
	4.438	+/-0.030	4.418	✓		vern	CNC-08
	113.20	+/-0.020	113.20	✓		tape	mm 502

Measured by: mm.L	Audited by: [Signature]	Preliminary Approval:
Date: 11/08/22	Date: 11-8-23	Date:

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ	
D	11.06.21	Tolerance revised for 4.438 dimension	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
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Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W 10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72592

DEO ATTACHED

ECW #11-615
11.07.26

UNDER REVIEW

RELEASED
08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D407-667-145 SHEET 1 OF 4 TITLE SCALE CROSSTUBE ASSY (407 HIGH FWD) NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.11.06	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

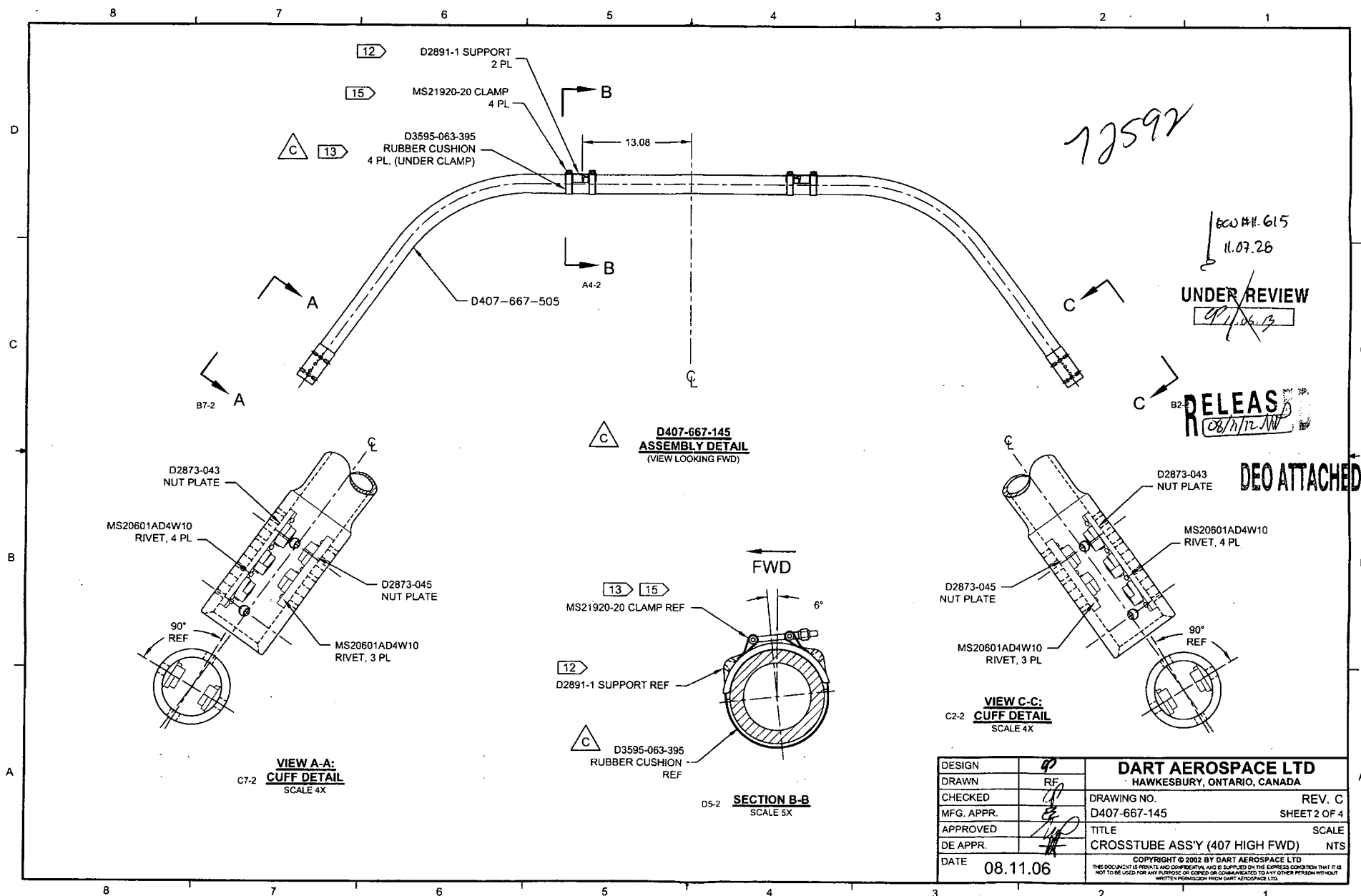
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



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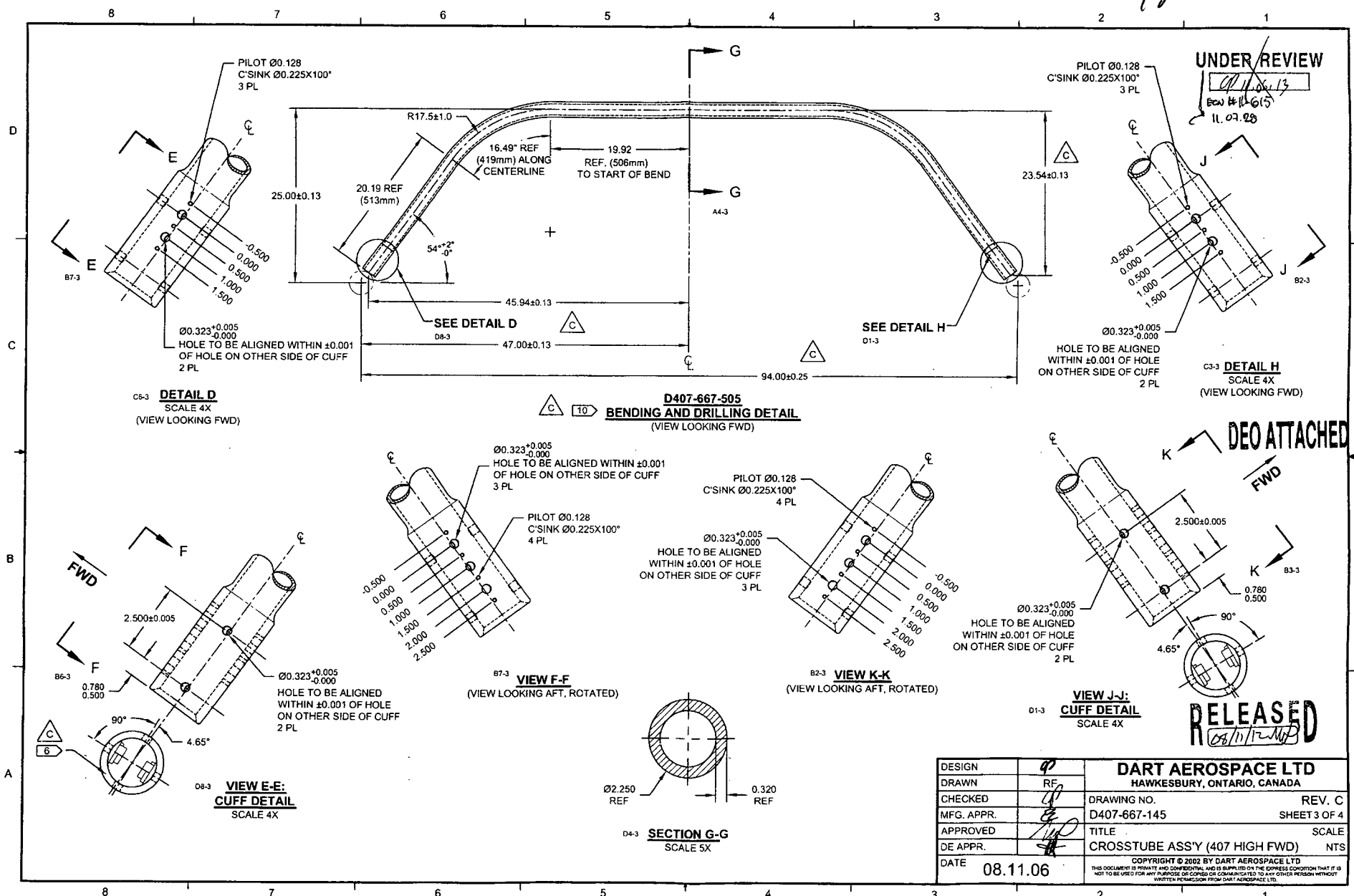
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72592



DESIGN	47	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. C
MFG. APPR.	47	D407-667-145	SHEET 3 OF 4
APPROVED	47	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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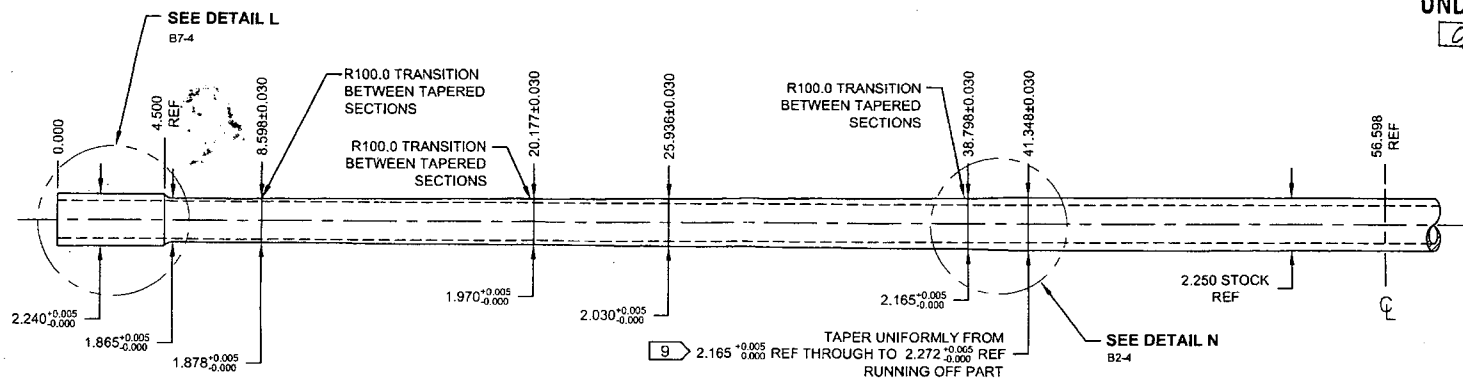
NOTE: Date & initial all entries

72592

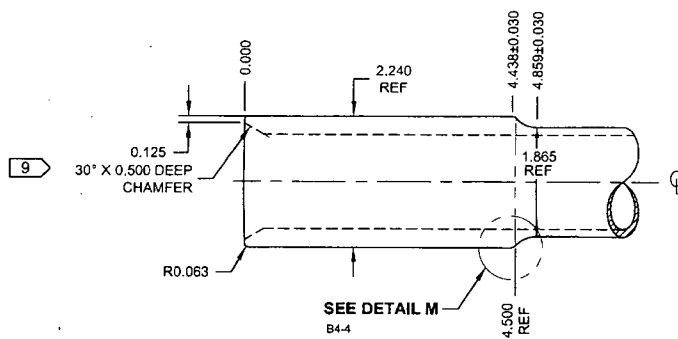
UNDER REVIEW

08/11/06

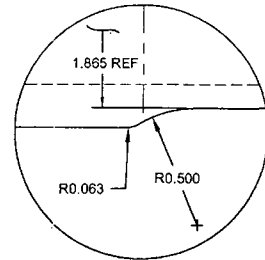
60111.615
11.07.26



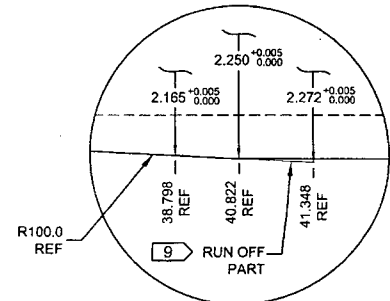
C TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

DEO ATTACHED

RELEASED
08/11/06

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D407-667-145	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DRAWING NO. D407-667-145	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-145-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>Q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>123</i>	APPROVED <i>WD</i>		DE APPR. <i>11</i>		
DATE 11.07.15	DATE 11.07.22	DATE 11.07.22	DATE 11/07/22		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -145	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II. CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WD

W/O:		WORK ORDER CHANGES					
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